

# Work Order ID 57615

April 9, 2010 8:02:53 PM



Page 1

Item ID: D3873-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 12/04/2010 Start Qty: 100.00



Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 100.00



Customer:

Reference:

*10.04.09*

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA806 & DWG D3873 ,

FOLIO REV: *A*

DWG REV: *SA 10/04/10*

2-DEBURR AS REQUIRED

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*SD 10/04/10*

*104*

*104*



## Lean Is...

- “LEAN IS – from an operations perspective... a system that cuts costs & inventories rapidly to free cash, which is critical in a slow economy. It also supports growth by improving productivity and quality, reducing lead times and freeing huge amounts of resources.
- Lean aims at reducing (if not eliminating) none value added activities in business processes.
- It's not a project.

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Set Up/  
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Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 093

0.00

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control



Cust Item ID:

Customer:



G.A 10/04/12

104 0

10/04/13 (104)

10/04/14 HJ

BS 10-4-13  
(104)



## Lean is...

- Promote customer-orientation rather than resource-orientation (produce for sales not for stock).
- A highly evolved method of managing an organization to improve the productivity, efficiency and quality of its products or services.
- Transforms how the company operates and how employees think about their work. Don't work harder but smarter by transferring your energy from the NVA to the VA activities.
- Has no end (there is no "done").

# Picklist Print

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Work Order ID: 57615



Parent Item: D3873-1

Parent Item Name: Bushing

Start Date: 12/04/2010

Required Date: 16/04/2010

Comments:

Start Qty: 100.00

Required Qty: 100.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No			100	f	87.5000	6.0000			



303 Round Bar 0.750



## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT028

87.5

113134

74

113365

3.9

113424

9.6

GRT SN 1010411

# Lean Is...

“LEAN IS... A mindset, or way of thinking

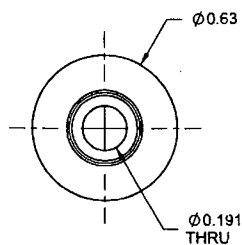
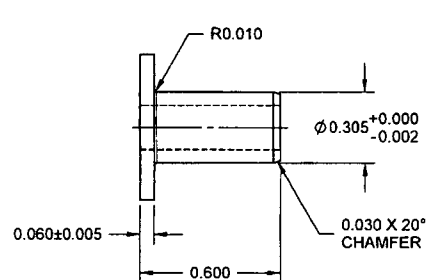
- A commitment to achieve a totally waste-free operation focused on the customer's success
- Achieved by simplifying and continuously improving all processes and relationships in an environment of trust, respect and full employee involvement
- It is about people, simplicity, flow, visibility, partnerships and true value as perceived by the customer.”



## Value stream mapping

- Value stream mapping is **the best way to identify where the high payoff** opportunities are, yet value stream mapping is the lean tool most likely to **not be used by** companies doing pretend lean!





**D3873-1 BUSHING**

RELEASE  
4 09.03.73  
PER ECN 44-538

u/o 57615

**NOTES:**

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR  
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

A	NEW ISSUE		MB	09.01.07
REV.		DESCRIPTION	BY	DATE
DESIGN	1	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA  DRAWING NO. <b>D3873</b>  TITLE <b>BUSHING</b>	REV.	
DRAWN	1		SHEET 1 OF	
CHECKED	115		SCALE	
MFG. APPR.	1		NT	
APPROVED	1			
DE APPR.	1			
DATE	09.01.07	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY.		



# Lean principle

To be able to produce exactly:

- **what is required**
- **when it is required**
- **the quantity required**

by the next step in the process.

**Once a job started, it should ideally never stop**